

Work Order ID 76438

76438

Page 1

November-14-11 2:25:59 PM

Item ID: D2571 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Fwd Out 205
 Start Date: 14/11/2011 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 02/12/2011 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 11/11/14 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2571	Rev E

100	HAAS CNC VERTICAL MACHINING #1	0.00	<u>29/ant 11/11/22</u>			<u>12</u>			
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100
HAAS 1

HAAS CNC vertical machine #1

Memo

Program Batch No. 76438 Double check by: ant 1-Machine Step No 1
 per Folio FA051 and inspect per attached Dimension Sheets2-Machine Step
 No 2 per Folio FA051 and inspect per attached Dimension Sheets3-Machine
 Step No 3 per Folio FA051 and inspect

110	CONVENTIONAL MILLING MACHINE	0.00	<u>29/ant 11/11/22</u>			<u>12</u>			
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110
Mill Conv

Conventional Milling Machine

Memo

Machine keyway as per dwg D2571 & D2572

120	QC2- Inspect parts off machine FAI/FAIB	0.00	<u>29/ant 11/11/22</u>			<u>12</u>			
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120
QC

Quality Control

Memo

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76438

76438

Page 2

November-14-11 2:25:59 PM

Item ID: D2571 Accept ***N900040100*** Setup Start ***NS1***
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 Item Name: Saddle, Fwd Out 205
 Start Date: 14/11/2011 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 02/12/2011 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		2L 11-11-28					
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140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
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150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 9:15 FINISH TIME: 9:45	0.00 0.00							
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M 118439

3200F

9:45

12 x 9 M/L 11/11/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 76438***76438***

Page 3

November-14-11 2:25:59 PM

Item ID: D2571

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Saddle, Fwd Out 205

Stop ***NS2***

Start Date: 14/11/2011 Start Qty: 12.00

12

Cust Item ID:

Required Date: 02/12/2011 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160 QC3- Inspect Part Finish 0.00

160

QC

Memo

0.00

Quality Control

12 BL 11-11-29170 Identify as per dwg & Stock Location: 433 0.00***170***

Packaging

Memo

0.00

Packaging

11/11/30 92 SP

180 QC21- Final Inspection - Work Order Release 0.00

180

QC

Memo

0.00

Quality Control

11/11/30 92 SPMF
11-11-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-14-11 2:26:03 PM

Page 1

Work Order ID: 76438

76438

Parent Item: D2571

D2571

Parent Item Name: Saddle, Fwd Out 205

Start Date: 14/11/2011

Required Date: 02/12/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: 102.10.02Re-format; Change to Dwg Rev. D & incorporated
D2572KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-007		Manufactured	No			100	Each	45.0000	1	12			

D6101-007

Saddle Billet

Location

Loc Qty

Loc Code

MAT

8

71722

8

MAT042

2

72228

2

MAT045

35

65383

1

65954

4

70680

6

73421

4

~~74781~~

20

12

and 11/11/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 76438
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.002	8.001	8.001		
F	0.490	0.510		.503	.503	.501	.503		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.499	.500	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.566	.566	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.125	.125	.125	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.257	.250	.257		
S	0.115	0.135		.130	.130	.132	.132		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.240	.239	.239	.240		
W	0.115	0.135		.124	.123	.122	.122		
X	0.308	0.313		.310	.311	.310	.311		
Y	0.760	0.765		.763	.763	.763	.762		
Z	0.352	0.372		.366	.366	.366	.366		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.627	.626	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.247	.248	.248	.246		
AE	1.375	1.395		1.388	1.388	1.388	1.3902		
AF	0.115	0.135		.134	.130	.134	.130		
AG	0.240	0.280		.266	.270	.255	.266		
AH	0.240	0.260		.248	.247	.247	.248		
AI	2.000	2.020		2.0015	2.0015	2.002	2.0058		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <i>am</i>
Date: 11/1/22

Audited by: <i>SL</i>
Date: 11-11-28

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 76438
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	16	17	18		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.001		
F	0.490	0.510		.501	.505	.502			
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.567	.568	.567	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.257	.257	.250	.257		
S	0.115	0.135		.132	.133	.131	.133		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.240	.241	.240	.240		
W	0.115	0.135		.123	.121	.123	.122		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.763	.763	.763	.763		
Z	0.352	0.372		.366	.367	.367	.367		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.626	.627	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.248	.247	.247	.248		
AE	1.375	1.395		1.388	1.3875	1.386	1.388		
AF	0.115	0.135		.132	.130	.131	.131		
AG	0.240	0.280		.260	.250	.260	.255		
AH	0.240	0.260		.248	.250	.249	.248		
AI	2.000	2.020		2.004	2.004	2.0017	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <i>DMF</i>
Date: 11/11/23

Audited by: <i>SL</i>
Date: 11-11-28

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order: 76438
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1/9	2/10	3/11	4/12	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.001		
F	0.490	0.510		.501	.501	.501	.501		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.567	.567	.567	.567		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.126	.125	.126	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.252	.252	.252	.252		
S	0.115	0.135		.131	.131	.131	.131		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.238	.238	.238	.238		
W	0.115	0.135		.121	.121	.121	.121		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.763	.763	.763	.763		
Z	0.352	0.372		.366	.366	.366	.366		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.626	.626	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.247	.247	.247	.247		
AE	1.375	1.395		1.389	1.387	1.387	1.387		
AF	0.115	0.135		.132	.132	.132	.132		
AG	0.240	0.280		.253	.253	.253	.253		
AH	0.240	0.260		.247	.247	.247	.247		
AI	2.000	2.020		2.004	2.002	2.002	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	AmL
Date:	11/11/23

Audited by:	JK
Date:	11-11-28

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

05.12.06

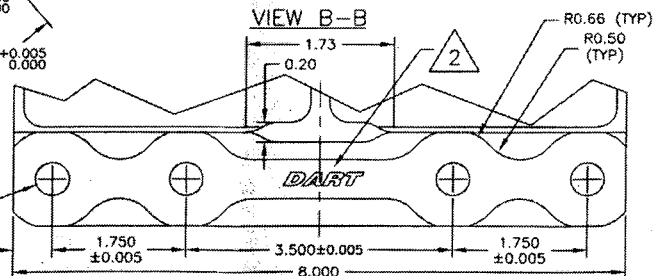
NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. D6102-001)
 FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 BREAK ALL SHARP EDGES 0.010 TO 0.020
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)

E

VIEW B-B



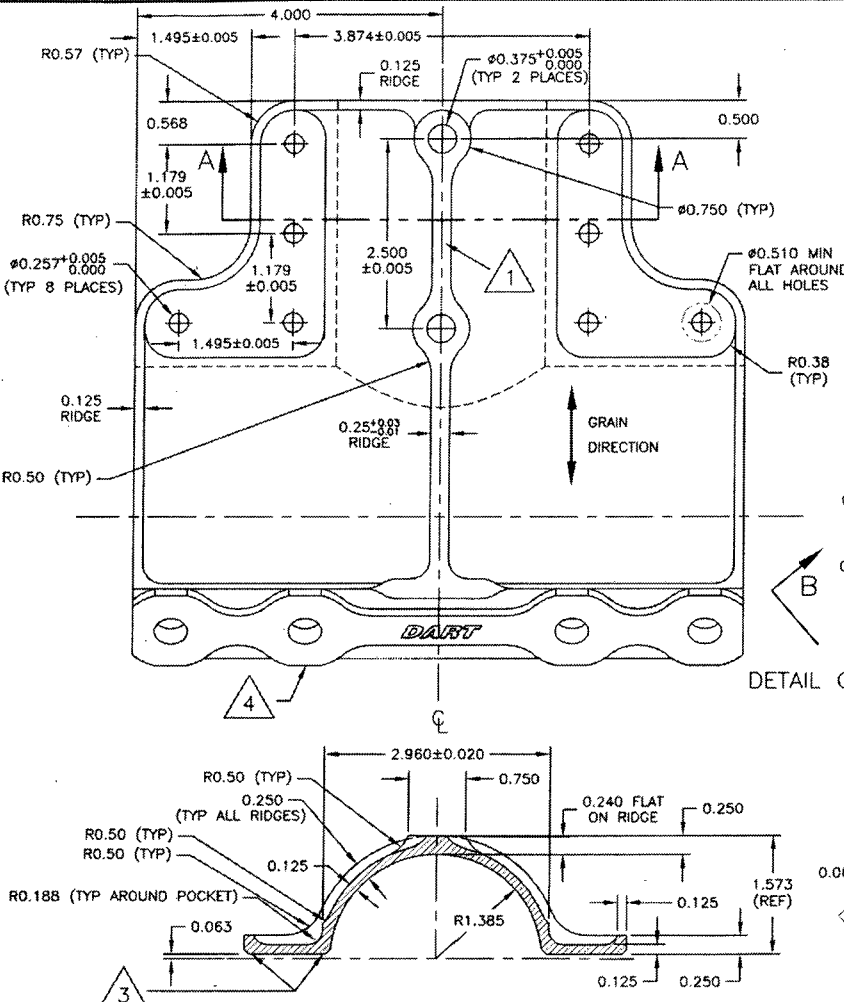
E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

DESIGN	DS	DRAWN BY	PH	DART	DART AEROSPACE LTD.
CHECKED	#	APPROVED	#		HAWKSBURY, ONTARIO, CANADA
DATE	05.07.13	DRAWING NO.	D2571	REV. E	SHEET 1 OF 1
		TITLE	OUTER FWD SADDLE	SCALE	2:3

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DETAIL C
 SCALE 4:3

SECTION A-A



SHOP COPY
 RETURN TO
 ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER

NO. 3010

M.C.J

76438

11/11/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries